

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020807**Date Inspected:** 28-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 12BE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld joint SEG3002B-003 located on Cross Beam side SP long seam as per WR # 16261. The welder is identified as 044779. ZPMC Quality Control (QC) is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the WPS 345-SMAW-4G(4F)-FCM-Repair. See attached photograph Pic_001.

OBG Segment 12CE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of Base Metal repair area located on Cross Beam side SP 3011A as per CWR # B-CWR-1914. The welder is identified as 044779. ZPMC Quality Control (QC) is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the WPS 345-SMAW-4G(4F)-FCM-Repair.

OBG Segment 12BW

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld joint CA3012-120 located on Counterweight side Drain Plate. The welder is identified as 205718. ZPMC Quality Control (QC) is identified as Wu Shi Gao. The welding variables recorded by QC appeared to comply with the WPS B-P-2114-FCM-1. See attached photograph Pic_002.

OBG Segment 12AW

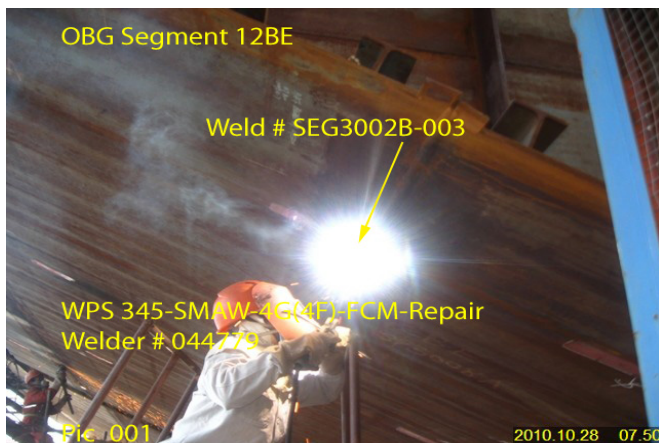
During in process inspection this QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) on Cross Beam side Corner Assembly SP to PP110 East welds.

Bay 16/ Steel Barriers

Flux Core Arc Welding (FCAW) in the 2F position of W5-SB1-049 Steel Barrier internals weld # W5-SB1-049-131. The welder is identified as 070217. ZPMC Quality Control (QC) is identified as Guo Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Bay 16/ Steel Barriers

Flux Core Arc Welding (FCAW) in the 3F position of W5-SB1-010 Steel Barrier internals weld # W5-SB1-010-018. The welder is identified as 068858. ZPMC Quality Control (QC) is identified as Guo Pin. The welding variables recorded by QC appeared to comply with WPS-B-T-2133.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Gade,Ramesh	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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